

A1.625

MAY BLACK-SHIP AUG 10

Work Order ID 72063

Tuesday, July 19, 2011 9:02:58 AM

Page 1

Item ID: D2594-1

Accept

Revision ID:

Item Name: Plug, 205 Skidtube

Start Date: 7/19/2011 Start Qty: 32.00

Required Date: 7/29/2011 Req'd Qty: 32.00

Reference:

Approvals:

Process Plan:

Date: 11-07-19 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2594

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262. □2-Break all sharp edges 0.010 max.

11/7/26

32

φ

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/7/26

32

φ

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11/07/26

32

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72063

Tuesday, July 19, 2011 9:02:58 AM



Page 2

Item ID: D2594-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plug, 205 Skidtube

Start Date: 7/19/2011 Start Qty: 32.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 32.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish					32	0	BL 11-826	
	Hand Finishing	0.00							
145		0.00							
	Spray Paint								
	Spray Painting								
	Memo								
	Prime								
	Spray Paint Matt Black Imron - DUP47-1640-0.8GL								
	B								
	per QSI 005 4.2								
155		0.00							
	QC14- Inspect Spray Paint								
	QC								
	Quality Control	0.00							
	Memo								

142 powder coat

Powder Coat Black Sandtex per QSI 005

B M115128

32 x 0 M-11/08/02

Start Time: 3:15
Temp: 320°F
Finish Time: 3:45

132 0 Jd 11/08/02

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 72063

Tuesday, July 19, 2011 9:02:58 AM



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Item ID: D2594-1

Accept



Setup Start



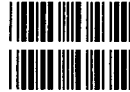
Revision ID:

Stop



Item Name: Plug, 205 Skidtube

Start Date: 7/19/2011 Start Qty: 32.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 32.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging	Identify as per dwg & Stock Location: <u>EP-1</u> Memo	0.00 0.00				<u>x32</u>	<u>0</u>	<u>11/08/03</u>	
170 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>OK 11/08/03</u>
Quality Control									

11-08-03
(32)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 9:03:05 AM

Page 1

Work Order ID: 72063

Parent Item: D2594-1

Parent Item Name: Plug, 205 Skidtube



Start Date: 7/19/2011

Required Date: 7/29/2011

Start Qty: 32.00

Required Qty: 32.00

Comments: IPP D 02.08.22 Make in Cobra KJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.625

Purchased

No

110

f

57.4900

0.0521

1.754947



6061-T6 Round Bar .625"

SA 11/7/26

Location

Loc Qty

Loc Code

MAT012

57.49

117284

47.4

117481

10.09

11/82

SA

W/O:		WORK ORDER CHANGES					
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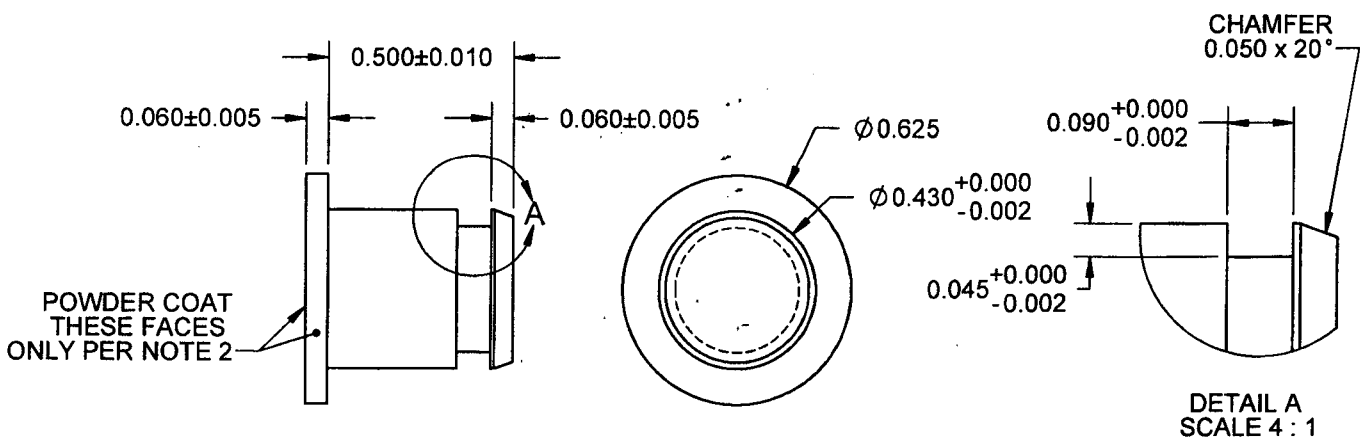
NOTE: Date & initial all entries

NO. 11074
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 TO
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 OFFICE
 ENDMENT
 SUPER



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG SCALE 2:1		
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
 06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

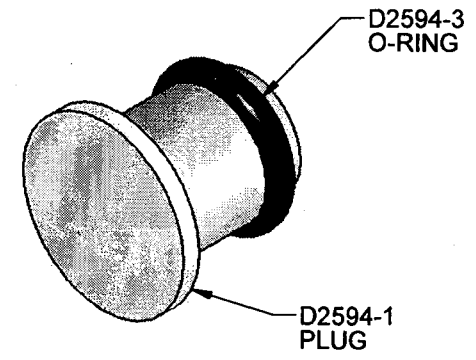
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 $\triangle C$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 $\triangle C$

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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